Qty:



Each

Date:

Tuesday, 2/28/2006 9:27:20 AM

User:

Kim Johnston

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 25959 **Estimate Number** : 11041

:N/A P.O. Number This Issue

S.O. No. : N/A : 2/28/2006

: NC Prsht Rev.

: 2/27/2006 First Issue

Type

: MACHINED PARTS

Checked & Approved By Comment

: Est C 02.03

Additional Product

Previous Run

Written By

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M6061T6R0500

6061-T6 Round Bar .500"

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

: BUSHING

: D2809

: N/A

: A1

AW:

: 3/10/2006

: D2809 REV A1

Comment: Qty.: 0.1045 f(s)/Unit

6061-T6 Round Bar .500"

Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Total:

2.6119 f(s)

HARDINGE 2.0

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA204

06/03/15

60

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(cO

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & deburr all sharp edges as per dwg

MS 06/03/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #: Fault Category:	NCR:	Yes (N	b) DQ	4 : 5	<u>)</u> Date: <u>∠</u>	50/B/01
			(QA: N/0	Closed	d:	_ Date: _	

NCR:			WORK ORD	DER NON-CONFORMANCE (NCR)						
		Department of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
				·						
			-							
.										

NOTE: Date & initial all entries

Tuesday, 2/28/2006 9:26:36 AM Date: Kim Johnston User: **Process Sheet Drawing Name: BUSHING** Customer: CU-DAR001 Dart Helicopters Services Part Number: D2809 Job Number: 25959 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 7.0 Comment: POWDER COATING per QSI 005 4.3 Powder coat INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DOCUMENT CONTROL 10.0 DC

Comment: DOCUMENT CONTROL

Inspection Level 21



U 060321

Job Completion

60

Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE		Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			.*						
		·							
Part No	•	PAR #:	Fault Cate	egory:	NCF	R: Yes N	lo DQA:_	Date: _	
						QA: N/	C Closed: _	Date: _	
NCR:		\	WORK ORD	ER NON-CONFO	RMANCE	(NCR))		
		Description of NC		Corrective Action Section B			Verification	on Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section C		QC Inspector
	1 1								

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCK)								
		Description of NC	Corrective Action Section B			Verification		A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector					
		· · · · · · · · · · · · · · · · · · ·											
			1 !				}						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25959	
Description: Spacer	Part Number:	D2809	
Inspection Dwg: D2809 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			•	
Ø0.191	+0.005/-0.000	.191				
Ø0.313	+0.005/-0.000	-313				
Ø0.500	+/-0.005	,500	W			
0.359	+/-0.010	,36a				
1.194	+/-0.010	1.193	/			
0.040 x 45°	+/-0.010	.C45	~			
R0.020	+/-0.010	P.010	~			
100						
						2
and the second s						

Measured by:	MS	Audited by:	me	Prototype Approval:	N/A
Date:	06/03/15	Date:	06/03/15	Date:	N/A

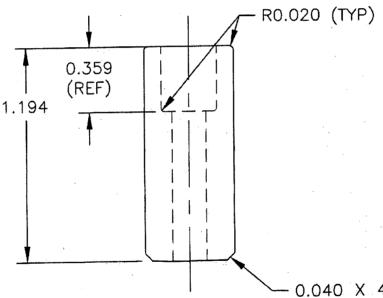
Rev	Date	Change	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM	





			A Company of the Comp			
)	DESIG	T T	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHEC	KED	APPROVED	DRAWING NO.	REV. A	
		P	4	D2809 SHEET	1 OF 1	
	DATE		<u> </u>	TITLE	SCALE	
	00.	11.07		SPACER .	2:1	
	Α		.00.11.07	NEW ISSUE		
	AI	1 P	01.04.26	ADD POWDER COAT; \$0.500 WAS \$0.507		

Ø0.313+ C'BORE 0.359 DEEP ØO.191 +8:005



0.040 X 45° CHAMFERPY

RETURN TO ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

NCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDI ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

L: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER CONT WHITE (43.5.1) OR GREY SANDTEX (43.5.6) OR BLACK SANDTEX (43.5.7) OR GREEN SANDTEX (43.5.8)

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